

Date: Thursday, 5/4/2006 11:09:28 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CAP
Job Number	: 26927		
Estimate Number	: 12401		
P.O. Number	: N/A	Part Number	: D31839
This Issue	: 5/4/2006 S.O. No. : N/A	Drawing Number	: D3183
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: C1
Previous Run	: N/A	Material	: N/A
Written By	: <u>See Comment Below</u>	Due Date	: 5/10/2006
Checked & Approved By	: <u>06.05.04</u>	Qty:	400 Um: Each
Comment	: Est A 06.05.03 New issue KJ		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

MDELRRN1000

Delrin Round Bar 1"



Comment: Qty.: 0.0350 f(s)/Unit Total : 13.9860 f(s)

Delrin Round Bar 1"

Material: Ø1.00 Delrin Rod

(M-DELRRN-R1.000)

Identify as D3183-9

Batch: 310067236 06.05.08 403

2.0

HARDINGE

HARDINGE CNC LATHE SMALL



Comment: HARDINGE CNC LATHE SMALL

Turn D3183-9 Cap as per Folio FA388

Deburr

36 06.05.08 403

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

36 06.05.08 403

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

36 06/05/08 403

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: N/A06.05.10403

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 2 Date: 06/05/11

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/4/2006 11:09:28 AM
User: Kim Johnston

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CAP

Job Number: 26927

Part Number: D31839

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

DP 0605/11 (H03)

Job Completion



u 06-05-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

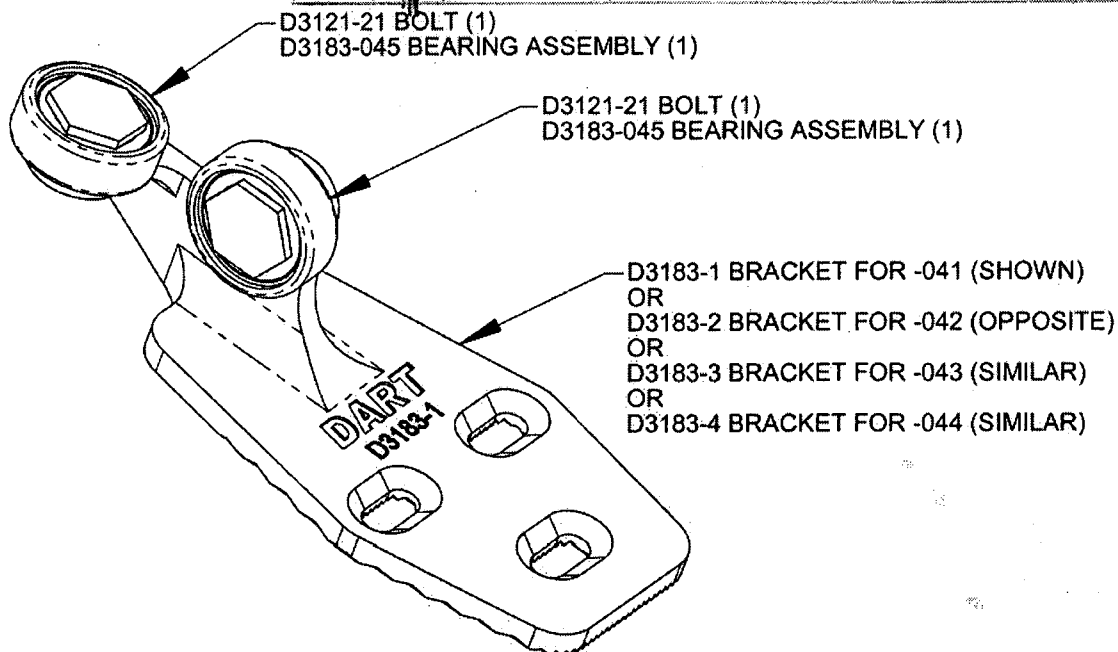
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

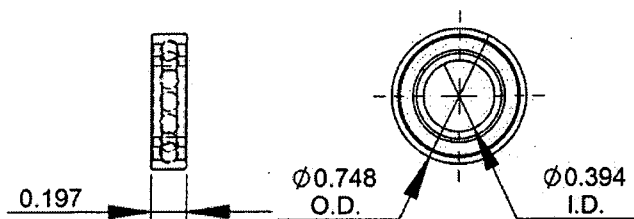


DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3183	REV. C SHEET 1 OF 4
DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1
A	03.01.24	NEW ISSUE	
B	03.06.17	REMOVE BEARING; 1.012 WS 0.882	
C	04.02.17	ADD -045/-9; 0.182 WAS 0.431	
CI	# 04.11.09	0.830 WAS 0.850	

RELEASED
04.03.01

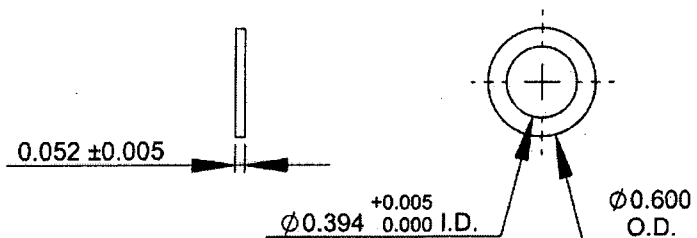


D3183-041 BRACKET ASSEMBLY (SHOWN)
D3183-042 BRACKET ASSEMBLY (OPPOSITE)
D3183-043 BRACKET ASSEMBLY (SIMILAR)
D3183-044 BRACKET ASSEMBLY (SIMILAR)



D3183-5 BEARING:
SPECIFICATION CONTROL DRAWING

- 1) SINGLE ROW, DEEP GROOVE, CONRAD TYPE, SHIELDED
- 2) POSSIBLE SUPPLIER: NSK P/N 6800ZZ
- 3) ALL DIMENSIONS ARE IN INCHES



D3183-7 WASHER

- 1) MATERIAL: AISI 303 ROUND BAR (M303R) ANNEALED
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER
NO. 26927

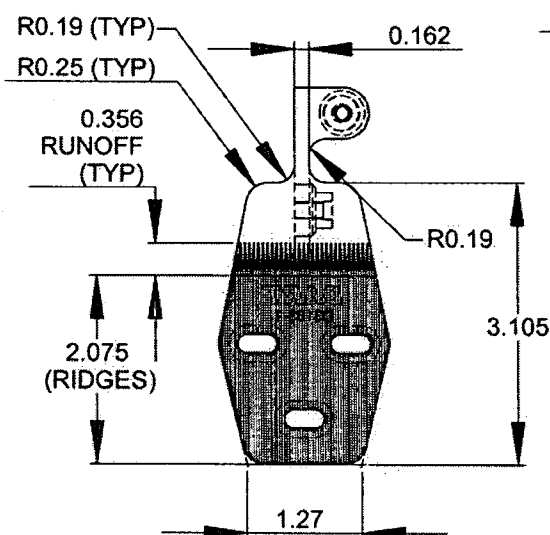
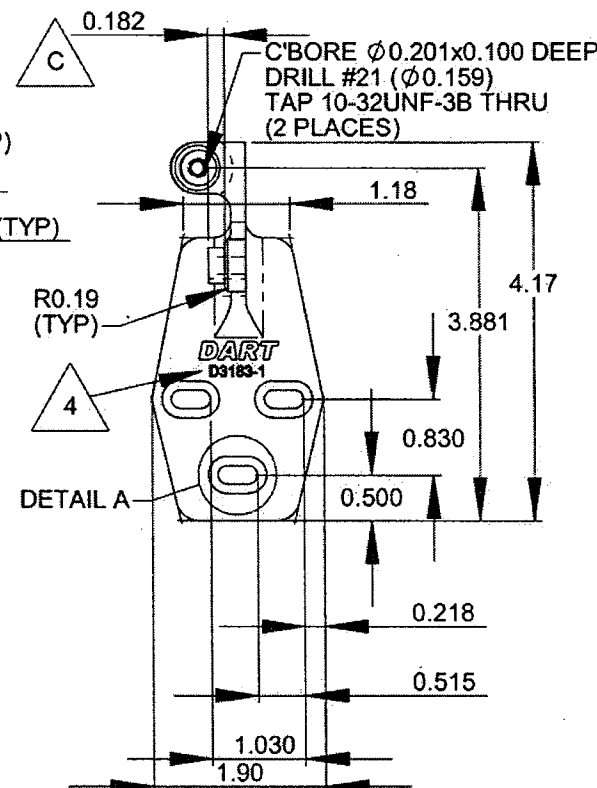
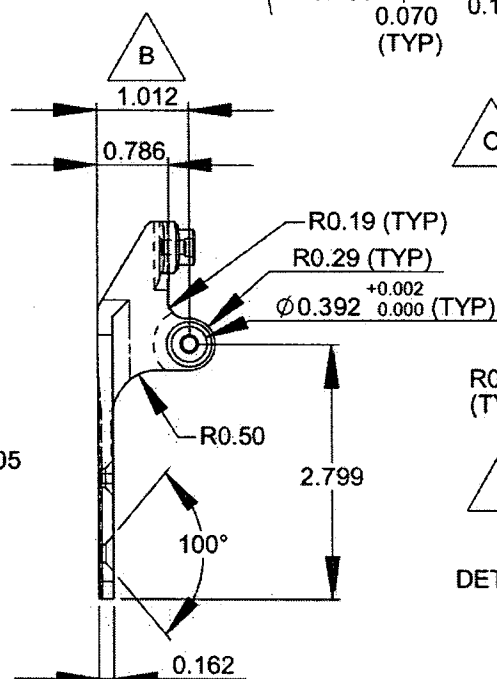
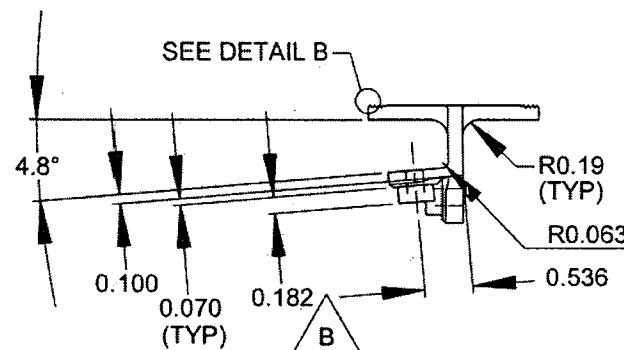
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DESIGN	DRAWN BY	TITLE	REV. C
<i>[Signature]</i>	<i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	SHEET 2 OF 4
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	D3183	SCALE 1:2
DATE 04.02.17		BRACKET ASSEMBLY	

RELEASED
04.03.01



**D3183-1 BRACKET SHOWN
D3183-2 BRACKET OPPOSITE**

- 1) D3183-1 CAN BE MADE FROM D3183-3
D3183-2 CAN BE MADE FROM D3183-4
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ENGRAVE DART P/N & LOGO AS SHOWN
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

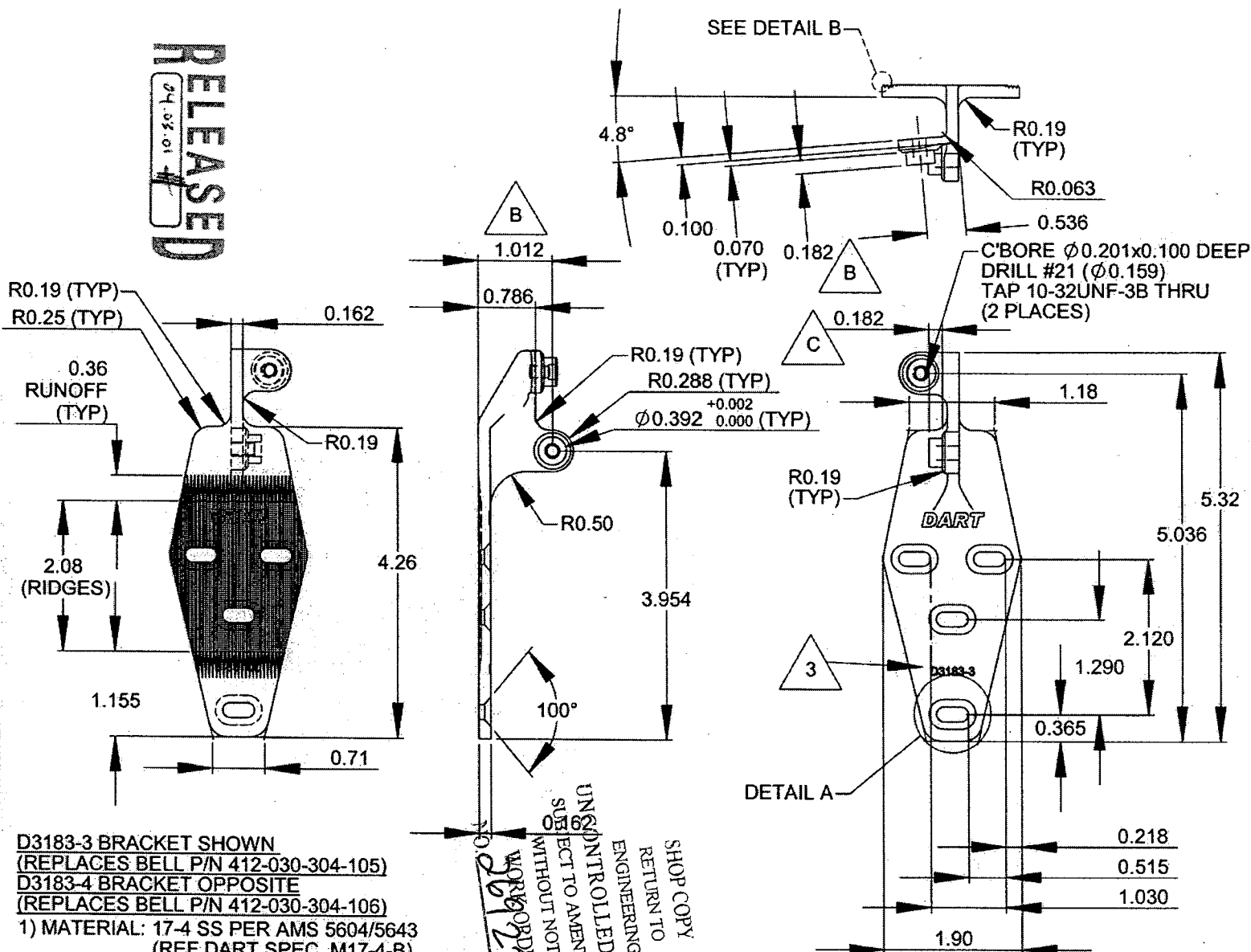
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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. C
				D3183	SHEET 3 OF 4
DATE	04.02.17			TITLE	SCALE
				BRACKET ASSEMBLY	1:2



D3183-3 BRACKET SHOWN
(REPLACES BELL P/N 412-030-304-105)
D3183-4 BRACKET OPPOSITE
(REPLACES BELL P/N 412-030-304-106)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE STRENGTH = 150 ksi
MIN YIELD STRENGTH = 100 ksi
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) ENGRAVE DART P/N & LOGO AS SHOWN
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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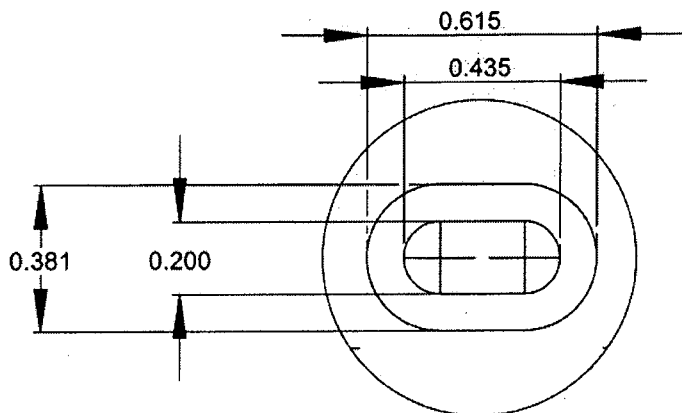
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24-03-01-#

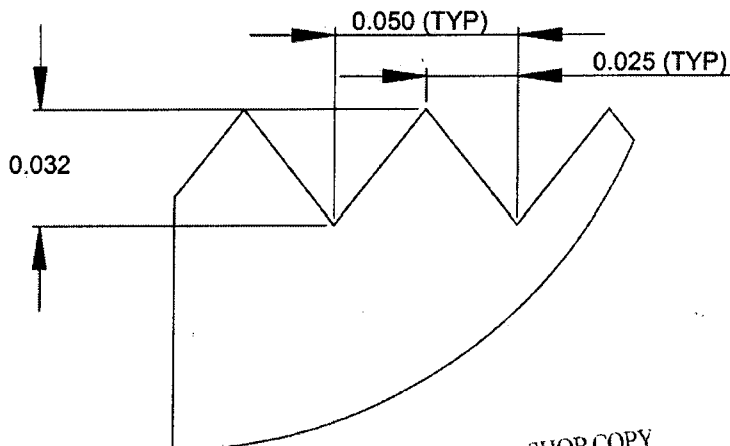


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DATE 04.02.17		TITLE BRACKET ASSEMBLY	SCALE 1:1



DETAIL A (2 : 1)

RELEASED
04.03.01



DETAIL B (20 : 1)

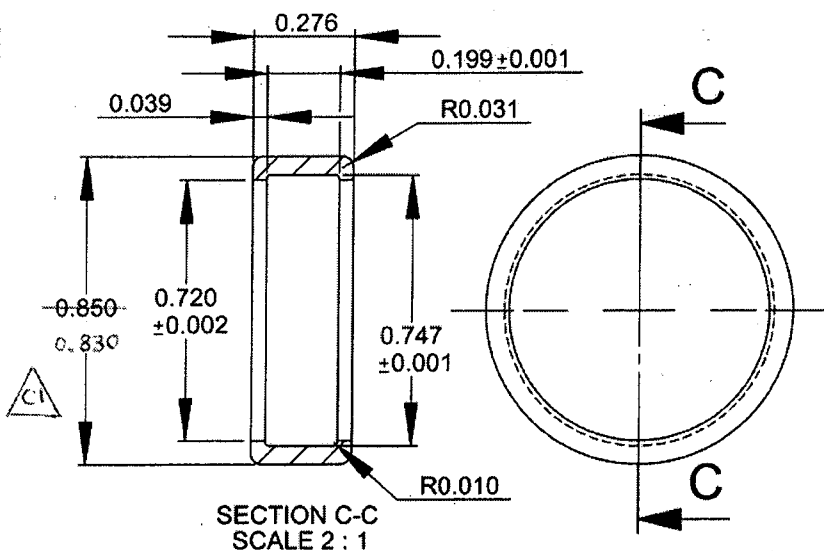
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WITHOUT NOTICE
WORK ORDER
26927

D3183-9 CAP NO. 26927

- 1) MATERIAL: DELRIN ROD, Ø1.00
(REF DART SPEC. M-DELRIN-R1.00)
- 2) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

D3183-045 BEARING ASSEMBLY

- 1) ASSEMBLE D3183-5 BEARING AND
D3183-9 CAP



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